

Split

Work Order ID 151903

151903

Page 1

Friday, October 14, 2016 1:54:59 PM

Item ID: D3278-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Assembly

Start Date: 11/24/2016 Start Qty: 20.00

20

30 HWS

Cust Item ID:

Required Date: 11/29/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: *VS* *DAS 21 9-89*

Date: *10/10/18*

Tooling:

Date:

Run Start

NR1

QC: *VS* *DAS 21 9-89*

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.10							
Small Fab	Rivet spacers with support as per Dwg D3278.								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.07							
Quality Control									
120		0.00							
120	Small Fab								
Small Fab	Memo	0.10							
Small Fab	Assemble support as per Dwg D3278.***DO NOT TIGHTEN BOLTS***Identify as D3278-041								

30 JAN 18 2017

DAS 6

30x

17/02/16
17/02/22
DAS 36 9-89

DAS 30 9-89

FEB 22 2017

1x

17/02/22
DAS 36 9-89

Friday, October 14, 2016 1:54:59 PM

Item ID: D3278-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS?

Item Name: Support Assembly

Start Date: 11/24/2016 **Start Qty:** 20.00

20

Cust Item ID:**Required Date:** 11/29/2016 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run

Start

NR1

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Picklist Print

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Friday, October 14, 2016 1:54:58 PM

Work Order ID: 151903

151903

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/24/2016

Required Date: 11/29/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A

Purchased

No

120

Each

452.0000

2

4060

AN4-13A

Bolt

**

JAN 18 2017

DAS
6
9-89LocationLoc QtyLoc Code

FG

20

122808

20

136263

GA

35

m134634

19

m135470

16

ST343

397

m134852

36

m135470

361

D2230-1

Manufactured

No

120

Each

158.0000

2

4060

D2230-1

Mounting Lug

**

JAN 18 2017

DAS
6
9-89LocationLoc QtyLoc Code

FG

2

84136

2

ST521

50

115306

1

146288

49

ST525A

106

150062

50

150063

56

153290 x 11

49

Picklist Print

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Friday, October 14, 2016 1:54:58 PM

Work Order ID: 151903

Parent Item: D3278-041

Parent Item Name: Support Assembly

151903

D3278-041

Start Date: 11/24/2016

Required Date: 11/29/2016

Start Qty: 20.00

Required Qty: 20.00

D3278-1
D3278-1
Support

Manufactured No

100 Each 53.0000 1 2030

**

Location

Loc Qty

Loc Code

GA

53

148978

20

150936

33

D3278-2
D3278-2
Support

Manufactured No

100 Each 54.0000 1 2030

**

Location

Loc Qty

Loc Code

GA

54

146068

18

150464

36

D3278-3
D3278-3
Spacer

Manufactured No

100 Each 78.0000 1 2030

**

Location

Loc Qty

Loc Code

GA

78

146065

1

149159

35

151010

42

MS20426AD3-6
MS20426AD3-6
Rivet

Purchased No

120 Each 2,848.000 4 80120

**

Location

Loc Qty

Loc Code

GA

1864

M133988

1864

ST312

984

M133988

984

DAS
36
9-89

151931 (12x)

152242 (18x)

DAS
36
9-89

B152336 (30x)

DAS
36
9-89

B156306 (1x)

B151287 (29x)

DAS
36
9-89

Picklist Print

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Friday, October 14, 2016 1:54:59 PM

Work Order ID: 151903

151903

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 11/24/2016

Required Date: 11/29/2016

Start Qty: 20.00

Required Qty: 20.00

MS21042L4

Purchased

No

100

Each

2,548.000

2

4060

MS21042L4

Nut

JAN 18 2017

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

260

m135058

260

OVER007

1500

m135774

500

m135864

1000

ST303

754

m135603

254

m135704

500

NAS1149D0463J

Purchased

No

120

Each

2,528.000

4

80120

NAS1149D0463J

Washer

JAN 18 2017

Location

Loc Qty

Loc Code

GA

135

M134508

32

M135056

103

ST260a

1000

M135767

1000

ST263

1393

M135530

393

M135671

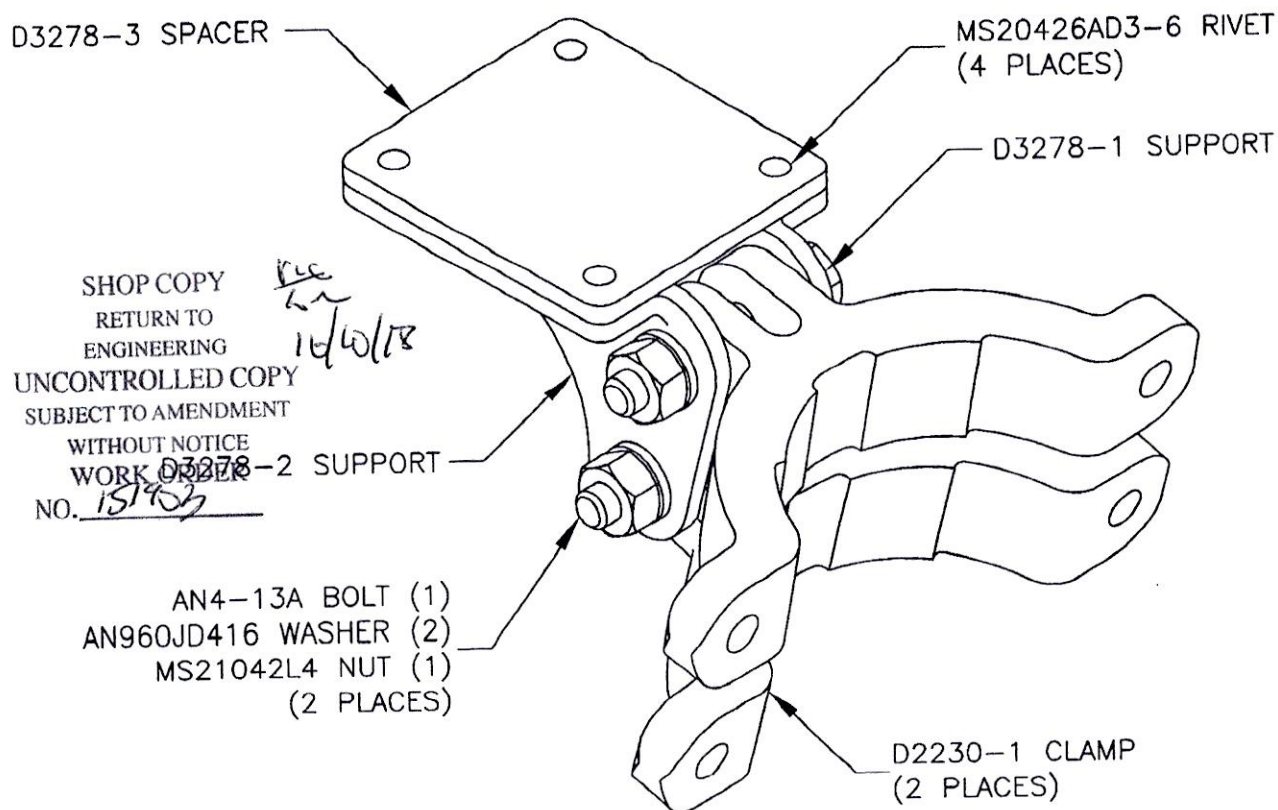
1000

DART

DESIGN <i>97</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07 08-06

D3278-041 SUPPORT ASSEMBLY



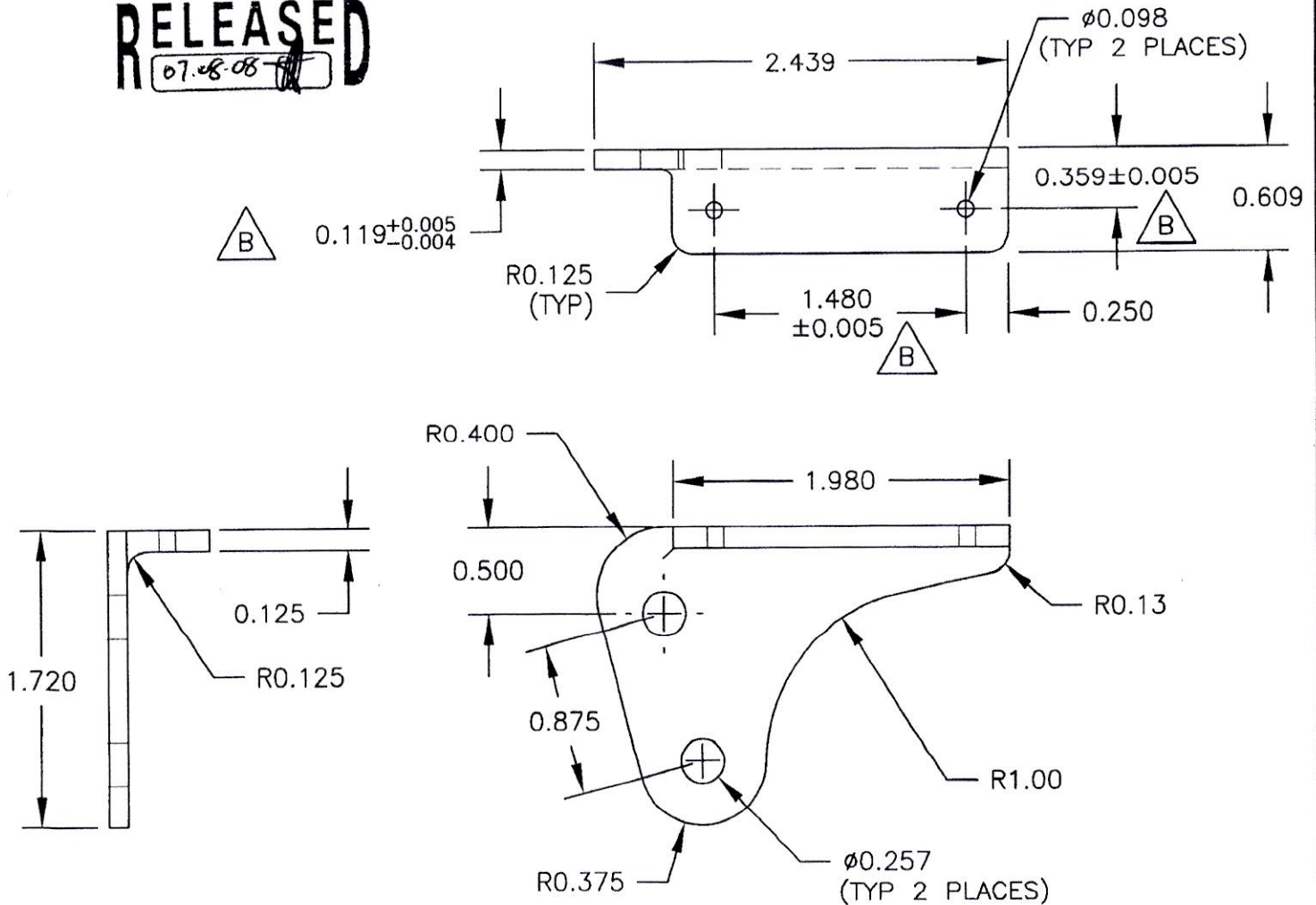
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DART

DESIGN 97	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

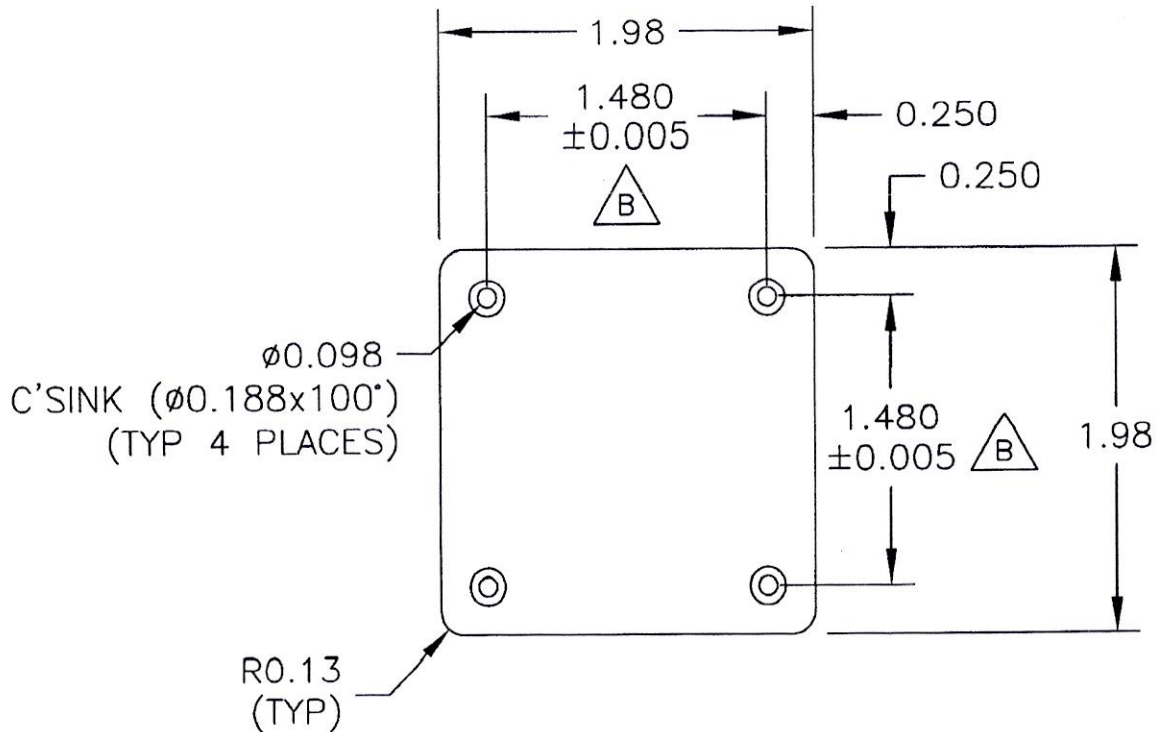
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART

DESIGN <i>qp</i>	DRAWN BY <i>sc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>3</i>	APPROVED <i>3</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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